

5/40

7

| | | |
|---------------------------------|--------------|-----------|
| DART AEROSPACE LTD | Work Order: | 24096 |
| Description: Support Assembly | Part Number: | D3278-041 |
| Dwg: D3278 Rev. 1 3/27/05.06-07 | Qty: | 100 98 |

Page 1 of 2

| Step | Location | Procedure | By | Date | Qty |
|------|----------|--|-----|-------------------------|-------------|
| 1 | DC | Issue Traveler DWG NOT REQUIRED ^{RF} 04.07.05 | JL | 05.08.23 | 100 |
| 2 | MV | Cut blanks: 2.00" x 1.00" x 2.550" long Material: 6061-T6/T651 (QQ-A-200/8) 1.00" thick (M6061T6B1.000x02.000) Identify for D3278-1 | | M17365 Batch: M18375 | JL 05.10.07 |
| 3 | MV | Cut blanks: 2.00" x 1.00" x 2.550" long Material: 6061-T6/T651 (QQ-A-200/8) 1.00" thick (M6061T6B1.000x02.000) Identify for D3278-2 | JL | 05.10.07 | 110 |
| 4 | MV | Machine D3278-1 as per Folio FA405 and Dwg D3278 Identify as D3278-1 | JL | 05.10.12 | 110 |
| 5 | QC2 | Inspect parts as they come off the CNC machine | JL | 05.10.12 | 110 |
| 6 | MV | Deburr and Tumble | JL | 05.10.12 | 110 |
| 7 | QC8 | Second check | | 05/10/12 | 110 |
| 8 | MV | Machine D3278-2 as per Folio FA405 and Dwg D3278 Identify as D3278-2 | JL | 05/10/17 | 100 |
| 9 | QC2 | Inspect parts as they come off the CNC machine | JL | 05/10/17 | 100 |
| 10 | MV | Deburr and Tumble | JL | 05.10.17 | 100 |
| 11 | QC8 | Second check | | 05/10/17 | 100 / 100 |
| 12 | FP | Acid etch and Alodine as per QSI 005 4.1 | SAD | 05/11/27 | 100 +10 |
| 13 | QC5 | Inspect work to Step 12 | | 05-11-28 | 100 |
| 14 | FP | Powder Coat Gloss White (Ref: 4.3.5.1) as per QSI 005 4.3 | ML | 06-01-09 | 110 |
| 15 | QC3 | Inspect Powder Coat | DL | 06/01/10 | 110 |
| 16 | GA | Rivet spacers with support as per Dwg D3278. (Note: D3278-11-2 are on BOM as material from Steps 2-3) Pick: Packing Kit | | | |
| | | Qty Part Number Description Batch | | | |
| | | 1 D3278-1 Support B24096 | | | |
| | | 1 D3278-2 Support B24096 | | | |
| | | 1 D3278-3 Spacer B24096 | | | |
| | | 4 MS20426AD3 Rivet M17694 | | | |
| | | | DC | 06/11/11 | 100 +10 |
| 17 | QC5 | Inspect work to Step 16 | JL | 06-04-12 | SS 100 |

RELEASED

11/04/04/22

| W/O: | | WORK ORDER CHANGES | | | | | |
|----------|------|---|----|----------|-----|---------------------------|-----------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Mfg / Design Mgr | Approval QC Inspector |
| 06/01/10 | 46 | Rivet MS 20426 AD 3-7 are too long need MS 20426 AD 3-6 same part change | SB | 06/01/10 | | <i>SB</i> <i>OBETK</i> | <i>Z</i> 06-01-11 |
| 06/01/11 | 16 | Stock leftover Qty. & Identify D 3278-1 Qty 10 | | | | <i>V</i> | <i>Z</i> 06-01-11 |

| | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|----------|------|---|-----------------------------|--|----------------------|---------------------------|--|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Design Mgr | Approval QC Inspector |
| | | | Initial Design Mgr | Action Description Design Mgr | Sign & Date | | | |
| 05/10/12 | 4 | - 10 parts are under tolerance - 119 ^{+ .005} - .004 3278-1 - ranging between .108 and .113 - are parts acceptable? | CP | PARTS ARE OK. WHEN ASSEMBLING, ENSURE PROPER BOLTS DO NOT Bottom OUT. | J.L 05.10.12 | <i>AB</i> 05-10-17 | <i>Q</i> 05.10.17 per QSI 042 | <i>AB</i> 05-10-17 |
| 05/10/17 | 8 | - 1 part is < 10 than 3278-2 - lifted in use | <i>AB</i> 05/10/17 | - scrap + replace | J.L 05/10/17 | <i>Z</i> 05-10-17 | <i>AB</i> 05/10/17 | <i>Z</i> 05-10-17 |
| 06/01/12 | 16 | Stock 10 parts of D 3278-1 1x D 3278-2 scrap. Drilled hole oversize when removing a rivet that was no good. | <i>AB</i> 06/01/12 | Stock leftover -1, no more -2 to complete part. | <i>Z</i> 06-01-12 | <i>Z</i> 06-01-12 | <i>AB</i> 06/01/12 | <i>Z</i> 06-01-12 |

Part No: D 3278-041

PAR #: _____

Fault Category: _____

NCR: Yes No DQA: *D*Date: 06/01/12

NOTE: Date & initial all entries

QA: N/C Closed: *QJ*Date: 06/01/12

| | | |
|---------------------------------------|--------------|--------------------|
| DART AEROSPACE LTD | Work Order: | 24096 |
| Description: Support Assembly | Part Number: | D3278-041 |
| Dwg: D3278 Rev. A <i>13 Jul 00-01</i> | Qty: | 100 Page 2 of 2 |

| Step | Location | Procedure | By | Date | Qty |
|------|----------|---|-----|----------|-----|
| 18 | GA | Assemble support as per Dwg D3278 Pick: Packing Kit <u>Qty</u> <u>Part Number</u> <u>Description</u> <u>Batch</u> 2 D2230-1 Clamp B23724/B 2 AN4-13A Bolt M184199 4 AN960JD416 Washer M184131 2 MS21042L4 Nut (or -4) M17997 | | | |
| | | Identify as D3278-041 Do NOT Tighten Bolts. | DL | 06/01/20 | |
| 19 | QC5 | Inspect work to Step 18 | SB | 06/01/20 | 98 |
| 20 | ST | Identify and Stock | CD | 06/01/20 | 98 |
| 21 | AC | Cost / part _____ | SAC | 06-01-25 | 98 |
| 22 | DC | Close W/O Inspect Level 21 | | 06/01/21 | 98 |

| Rev | Date | Change | Revised By | Approved |
|-----|----------|-----------|------------|-----------------|
| A | 04.04.19 | New issue | KJ/JLM | <i>04.04.22</i> |

RELEASED

04.04.22

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|---------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Mfg / Design Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|----------------------------------|----------------|---------------------------|------------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Design Mgr | Approval QC Inspector |
| | | | Initial Design Mgr | Action Description Design Mgr | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

| | | |
|-----------------------|--------------|-------------|
| DART AEROSPACE LTD | Work Order: | 24096 |
| Description: Support | Part Number: | D3278-1 |
| Inspection Dwg: D3278 | Rev: B | Page 1 of 1 |

FIRST ARTICLE INSPECTION CHECKLIST

First Article Prototype

| Drawing Dimension | Tolerance | Actual Dimension | Accept | Reject | Method of Inspection | Comments |
|-------------------|---------------|------------------|--------|--------|----------------------|----------|
| Ø0.098 | +0.005/-0.000 | .100 | ✓ | | | |
| 0.359 | +/-0.005 | .359 | ✓ | | | |
| 0.605 | +/-0.010 | .615 | ✓ | | | |
| 0.250 | +/-0.010 | .250 | ✓ | | | |
| 1.480 | +/-0.005 | 1.478 | | | | |
| R0.125 | +/-0.010 | .125 | ✓ | | | |
| 0.119 | +0.005/-0.004 | .124 | ✓ | | | |
| 2.439 | +/-0.010 | 2.439 | ✓ | | | |
| | | | | | | |
| 1.980 | +/-0.010 | 1.985 | ✓ | | | |
| R0.130 | +/-0.010 | .130 | ✓ | | | |
| Ø0.257 | +0.005/-0.000 | .260 | ✓ | | | |
| R0.375 | +/-0.010 | 375 | ✓ | | | |
| 0.875 | +/-0.010 | .874 | ✓ | | | |
| 0.500 | +/-0.010 | .500 | ✓ | | | |
| R0.400 | +/-0.010 | .400 | ✓ | | | |
| | | | | | | |
| 1.720 | +/-0.010 | 1.721 | ✓ | | | |
| R0.125 | +/-0.010 | .125 | ✓ | | | |
| 0.125 | +/-0.010 | .128 | ✓ | | | |
| | | | | | | |
| | | | | | | |

| | | | | | |
|--------------|----------|-------------|----------|---------------------|-----|
| Measured by: | J.L. | Audited by: | G. | Prototype Approval: | N/A |
| Date: | 05.10.07 | Date: | 05/10/07 | Date: | N/A |

| Rev | Date | Change | Revised by | Approved |
|-----|----------|----------------------------------|------------|----------|
| A | 04.04.19 | New Issue P/O D3278-041 | KJ/JLM | |
| B | 05.06.08 | 0.359 was 0.365; 0.119 was 0.125 | KJ/JLM | |

RELEASED
05/06/08

| | | |
|-----------------------|--------------|-------------|
| DART AEROSPACE LTD | Work Order: | 24096 |
| Description: Support | Part Number: | D3278-2 |
| Inspection Dwg: D3278 | Rev: B | Page 1 of 1 |

FIRST ARTICLE INSPECTION CHECKLIST

First Article Prototype

| Drawing Dimension | Tolerance | Actual Dimension | Accept | Reject | Method of Inspection | Comments |
|-------------------|---------------|------------------|--------|--------|----------------------|----------|
| Ø0.098 | +0.005/-0.000 | .099 | ✓ | | | |
| 0.359 | +/-0.005 | .359 | ✓ | | | |
| 0.615 | +/-0.010 | .612 | ✓ | | | |
| 0.250 | +/-0.010 | .251 | ✓ | | | |
| 1.480 | +/-0.005 | 1.480 | ✓ | | | |
| R0.125 | +/-0.010 | .125 | ✓ | | | |
| 0.119 | +0.005/-0.004 | .122 | ✓ | | | |
| 2.439 | +/-0.010 | 2.440 | ✓ | | | |
| | | | | | | |
| 1.980 | +/-0.010 | 1.982 | ✓ | | | |
| R0.130 | +/-0.010 | .130 | ✓ | | | |
| Ø0.257 | +0.005/-0.000 | .259 | ✓ | | | |
| R0.375 | +/-0.010 | .375 | ✓ | | | |
| 0.875 | +/-0.010 | .875 | ✓ | | | |
| 0.500 | +/-0.010 | .500 | ✓ | | | |
| R0.400 | +/-0.010 | .400 | ✓ | | | |
| | | | | | | |
| 1.720 | +/-0.010 | 1.721 | ✓ | | | |
| R0.125 | +/-0.010 | .125 | ✓ | | | |
| 0.125 | +/-0.010 | .127 | ✓ | | | |
| | | | | | | |
| | | | | | | |

| | | | | | |
|--------------|----------|-------------|----------|---------------------|-----|
| Measured by: | J.L | Audited by: | E.P | Prototype Approval: | N/A |
| Date: | 05/10/15 | Date: | 05/10/15 | Date: | N/A |

| Rev | Date | Change | Revised by | Approved |
|-----|----------|----------------------------------|------------|--------------------|
| A | 04.04.19 | New Issue P/O D3278-041 | KJ/JLM | |
| B | 05.06.08 | 0.359 was 0.365; 0.119 was 0.125 | KJ/JLM | <i>[Signature]</i> |

RELEASED
05/10/2015

Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

Aug 18, 2005
10:59 am

| | | | |
|-------------------|---|------------------|------------------------------|
| Work Order No | : | 0024096 | Department Code: |
| Project Name | : | D3278-041 | Burden Flags : NNNNNNNN |
| Project For | : | WK540 | WO Status : Open |
| Work Order Type | : | Main | Invoice State : Not Invoiced |
| Main WO Number | : | | Invoice Date : |
| House Part Number | : | D3278-041 | Invoice Number : |
| Description | : | Support Assembly | Invoice Amount : 0.00 |
| Manufactured | : | Yes | |
| Amount Req'd | : | 100 | |
| Amount Done | : | 0 | Order Entry No : |
| Start Date | : | 08-17-05 | OE Value : 0.00 |
| Est Finish Date | : | | Est Mark Up : 0.000% |
| Act Finish Date | : | | Actual Mark Up : 0.000% |
| Drawings Reqd | : | No | |
| Ok for Approval | : | | |
| Approval Rec'd | : | | \$0 Posted to Finished Goods |

| | Estimated | Actual | Var. % | Posted | To Post |
|-------------------|-----------|--------|--------|--------|---------|
| Material Cost | : 0.00 | 0.00 | 0.00 | 0.00 | 0.00 |
| Engineering Hours | : 0.00 | 0.00 | 0.00 | | |
| Engineering Cost | : 0.00 | 0.00 | 0.00 | 0.00 | 0.00 |
| Production Hours | : 0.00 | 0.00 | 0.00 | | |
| Production Cost | : 0.00 | 0.00 | 0.00 | 0.00 | 0.00 |
| Packaging Hours | : 0.00 | 0.00 | 0.00 | | |
| Packaging Cost | : 0.00 | 0.00 | 0.00 | 0.00 | 0.00 |
| OverHead Hours | : 0.00 | 0.00 | 0.00 | | |
| OverHead Cost | : 0.00 | 0.00 | 0.00 | 0.00 | 0.00 |
| CNC Hours | : 0.00 | 0.00 | 0.00 | | |
| CNC | : 0.00 | 0.00 | 0.00 | 0.00 | 0.00 |
| Misc. Hours | : 0.00 | 0.00 | 0.00 | | |
| Misc. | : 0.00 | 0.00 | 0.00 | 0.00 | 0.00 |
| <hr/> | <hr/> | <hr/> | <hr/> | <hr/> | <hr/> |
| Burden | : 0.00 | 0.00 | 0.00 | | |
| <hr/> | <hr/> | <hr/> | <hr/> | <hr/> | <hr/> |
| Total Cost | : 0.00 | 0.00 | 0.00 | | |
| Mark up | : 0.000 | 0.000 | | | |
| Selling Cost | : 0.00 | 0.00 | | | |

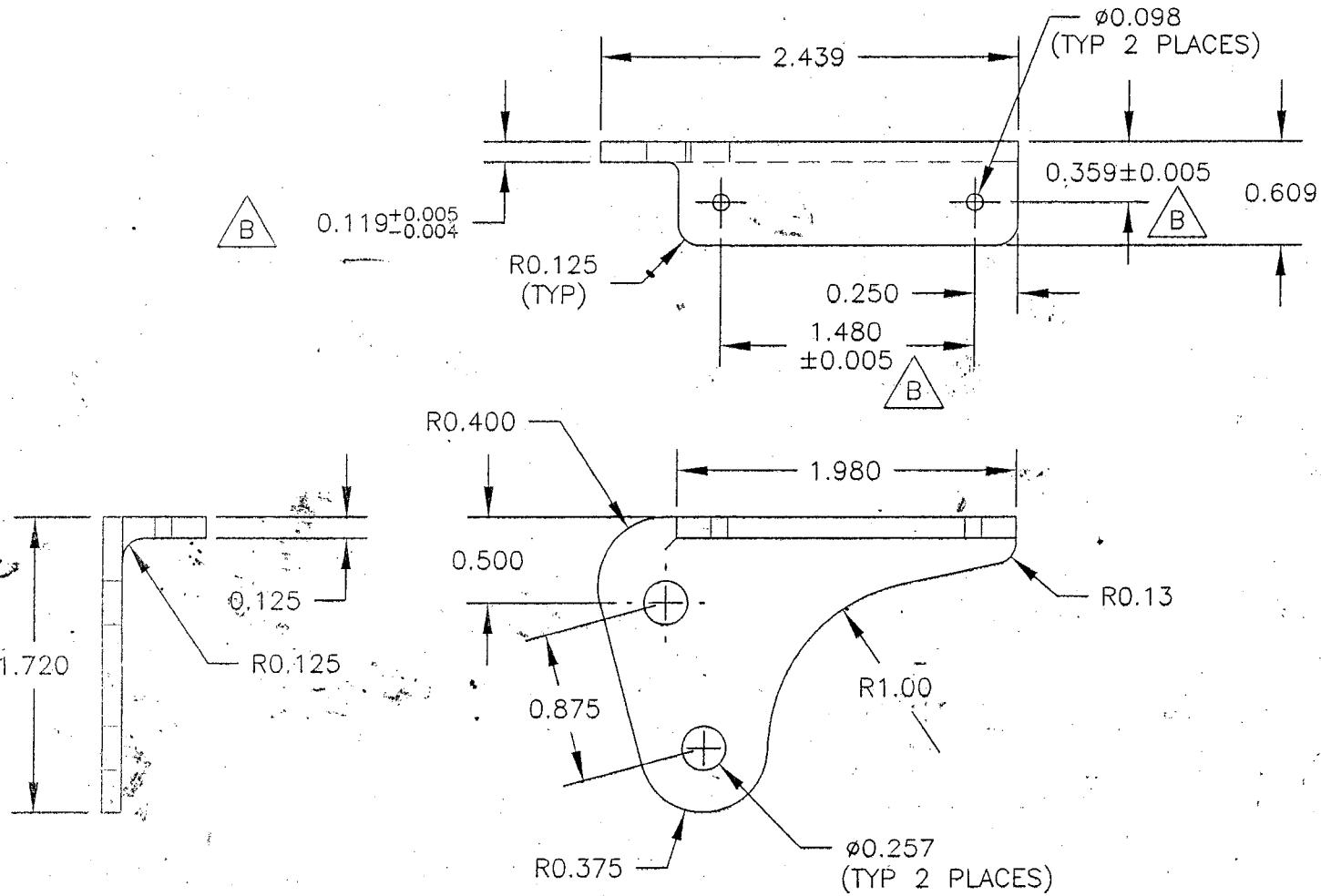
| | Estimated | Actual |
|------------------------|-----------|--------|
| Labour Hrs/Amount Done | : 0.00 | 0.00 |
| Profits/ (Loss) | : 0.00 | 0.00 |

DART

CONTROLLED COPY

| | | | |
|-------------------------------|--------------------------------|---|------------------------|
| DESIGN CP | DRAWN BY CP | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| CHECKED <i>[Signature]</i> | APPROVED <i>[Signature]</i> | DRAWING NO. D3278 | REV. B SHEET 2 OF 3 |
| DATE 05.03.31 | | TITLE SUPPORT ASSEMBLY | SCALE 1:1 |

RELEASED

05.04.04 *[Signature]*D3278-1 SUPPORT (SHOWN)D3278-2 SUPPORT (OPPOSITE)

- 1) MACHINE PER DWG FILE "D3278-1.SLDPRPT"
- 2) MATERIAL: 6061-T6/T651 (QQ-A-200/8 OR QQ-A-250/8 OR QQ-A-250/11)
(REF DART SPEC. M6061T6B OR M6061T6S)
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 4) BREAK ALL SHARP EDGES: 0.005 TO 0.015
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

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Chris Provencal

From: David Shepherd [davids@dartaero.com]
Sent: October 12, 2005 10:16 PM
To: Chris Provencal
Subject: Re: D3278 problem

Structurally, I don't see a problem with the thin parts. I would double check that the assembly works OK with the plastic spacers and the clamps before signing these parts off.

David

----- Original Message -----

From: "Chris Provencal" <cprovencal@dartaero.com>
To: <davids@dartaero.com>
Sent: Wednesday, October 12, 2005 10:42 AM
Subject: D3278 problem

> David,
>
> They made (10) D3278-1 brackets (that's the bracket for the fwd 350 step
> clamp) with a reduced wall thickness. The end of the piece was lifting on
> the machine, so the wall tapers from nominal down to 0.108" (minimum) at
the
> lower hole. The nominal is 0.119 +0.005 -0.004.
>
> They've fixed the problem so this didn't happen on the rest of the batch.
>
> Is this acceptable.
>
> -Chris
>
>
>

Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

Nov 08, 2005
10:52 am

| | | | |
|-------------------|---|------------------|------------------------------|
| Work Order No | : | 0024096 | Department Code: |
| Project Name | : | D3278-041 | Burden Flags : NNNNNNNN |
| Project For | : | WK540 | WO Status : Open |
| Work Order Type | : | Main | Invoice State : Not Invoiced |
| Main WO Number | : | | Invoice Date : |
| House Part Number | : | D3278-041 | Invoice Number : |
| Description | : | Support Assembly | Invoice Amount : 0.00 |
| Manufactured | : | Yes | |
| Amount Req'd | : | 100 | |
| Amount Done | : | 0 | Order Entry No : |
| Start Date | : | 08-17-05 | OE Value : 0.00 |
| Est Finish Date | : | | |
| Act Finish Date | : | | Est Margin : 0.000% |
| Drawings Reqd | : | No | Actual Margin : 0.000% |
| Ok for Approval | : | | |
| Approval Rec'd | : | | \$0 Posted to Finished Goods |

| | Estimated | Actual | Var. % | Posted | To Post |
|-------------------|-----------|---------|--------|--------|---------|
| Material Cost | : 0.00 | 0.00 | 0.00 | 0.00 | 0.00 |
| Engineering Hours | : 0.00 | 0.00 | 0.00 | | |
| Engineering Cost | : 0.00 | 0.00 | 0.00 | 0.00 | 0.00 |
| Production Hours | : 0.00 | 83.75 | 100.00 | | |
| Production Cost | : 0.00 | 1492.19 | 100.00 | 0.00 | 1492.19 |
| Packaging Hours | : 0.00 | 0.00 | 0.00 | | |
| Packaging Cost | : 0.00 | 0.00 | 0.00 | 0.00 | 0.00 |
| OverHead Hours | : 0.00 | 0.00 | 0.00 | | |
| OverHead Cost | : 0.00 | 0.00 | 0.00 | 0.00 | 0.00 |
| CNC Hours | : 0.00 | 83.75 | 100.00 | | |
| CNC | : 0.00 | 0.00 | 0.00 | 0.00 | 0.00 |
| Misc. Hours | : 0.00 | 0.00 | 0.00 | | |
| Misc. | : 0.00 | 0.00 | 0.00 | 0.00 | 0.00 |
| <hr/> | | | | | |
| Burden | : 0.00 | 0.00 | 0.00 | | |
| <hr/> | | | | | |
| Total Cost | : 0.00 | 1492.19 | 100.00 | | |
| Margin | : 0.000 | 0.000 | | | |
| Selling Cost | : 0.00 | 1492.19 | | | |

| | Estimated | Actual |
|------------------------|-----------|-------------|
| Labour Hrs/Amount Done | : 0.00 | 0.00 |
| Profits/ (Loss) | : 0.00 | (-1492.19) |

Date: Monday, 14/11/2005 8:35:35 AM
 User: Alba Panzuto

Process Sheet

| | | | | | | |
|----------------------------------|---------------------------------------|--|---------------------|-------------------------|--------------|-----------------|
| Customer | : CU-DAR001 Dart Helicopters Services | | Drawing Name | : SUPPORT ASSEMBLY | | |
| Job Number | : 24096 | | | | | |
| Estimate Number | : 10464 | | | | | |
| P.O. Number | : | | | Part Number | : D3278041 | |
| This Issue | : 14/11/2005 | | S.O. No. | : D3278 REV. B | | |
| Prsht Rev. | : NC | | | Project Number | : | |
| First Issue | : / / | | Type | : SMALL /MED FAB | | |
| Previous Run | : | | | Drawing Revision | : B | |
| Written By | : | | | Material | : | |
| Checked & Approved By | : | | | Due Date | : 30/11/2005 | |
| Comment | : Est:A 04.04.19 New issue KJ/JLM | | | Qty: | 100 | Um: Each |

Additional Product

Job Number:



| Seq. #: | Machine Or Operation: | Description : | |
|---|-----------------------|-------------------------------|--|
| 1.0 | 24096A | SUPPORT | |
| 2.0 | 24096B | SUPPORT | |
| Comment: Sub-Component SUPPORT | | | |
| 3.0 | D32781 | SUPPORT | |
| 4.0 | D32782 | SUPPORT | |
| 5.0 | D32783 | Spacer | |
| 6.0 | MS20426AD37 | RIVET | |
| 7.0 | SMALL FAB 1 | SMALL & MEDIUM FAB RESOURCE 1 | |
| Comment: SMALL & MEDIUM FAB RESOURCE 1 Rivet spacers with support as per Dwg D3278. | | | |
| 8.0 | QC5 | INSPECT WORK TO CURRENT STEP | |
| Comment: INSPECT WORK TO CURRENT STEP | | | |
| 9.0 | D22301 | Mounting Lug | |
| 10.0 | AN413A | Bolt | |
| 11.0 | AN960JD416 | Washer | |
| 12.0 | MS21042L4 | Nut | |
| 13.0 | SMALL FAB 1 | SMALL & MEDIUM FAB RESOURCE 1 | |
| Comment: SMALL & MEDIUM FAB RESOURCE 1 Assemble support as per Dwg D3278. ***DO NOT TIGHTEN BOLTS*** | | | |

Date: Monday, 14/11/2005 8:35:35 AM
User: Alba Panzuto

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SUPPORT ASSEMBLY

Job Number: 24096

Part Number: D3278041

Job Number:



| Seq. #: | Machine Or Operation: | Description : |
|---|-----------------------|------------------------------|
| Identify as D3278-041 | | |
| 14.0 | QC5 | INSPECT WORK TO CURRENT STEP |
| | | |
| Comment: INSPECT WORK TO CURRENT STEP | | |
| 15.0 | PACKAGING 1 | PACKAGING RESOURCE #1 |
| | | |
| Comment: PACKAGING RESOURCE #1 Identify and Stock Location: _____ | | |
| 16.0 | DC | DOCUMENT CONTROL |
| | | |
| Comment: DOCUMENT CONTROL Inspection Level 21 | | |

Job Completion



Date: Monday, 14/11/2005 8:35:37 AM
 User: Alba Panzuto

Process Sheet

| | | | | | | | |
|----------------------------------|---------------------------------------|--|--|-------------------------|--|--|--|
| Customer | : CU-DAR001 Dart Helicopters Services | | | Drawing Name | : SUPPORT | | |
| Job Number | : 24096A | | | Part Number | : D32781 | | |
| Estimate Number | : 10452 | | | Drawing Number | : D3278 REV. B | | |
| P.O. Number | : | | | Project Number | : | | |
| This Issue | : 14/11/2005 S.O. No. : | | | Drawing Revision | : B | | |
| Prsht Rev. | : NC | | | Material | : | | |
| First Issue | : / / Type : SMALL /MED FAB | | | Due Date | : 30/11/2005 Qty: 100 Um: Each | | |
| Previous Run | : | | | | | | |
| Written By | : | | | | | | |
| Checked & Approved By | : | | | | | | |
| Comment | : Est:A 04.04.19 New issue KJ/JLM | | | | | | |

Additional Product

Job Number:



| Seq. #: | Machine Or Operation: | Description : |
|--|-----------------------|--|
| 1.0 | M6061T6B1000X02000 | 6061-T6 Bar 1.0" x 2.0" |
| 2.0 | SHEAR | SHEAR |
| | | |
| Comment: SHEAR Cut blank: 2.00" x 1.00" x 2.550" long | | |
| 3.0 | HAAS1 | HAAS CNC VERTICAL MACHINING #1 |
| | | |
| Comment: HAAS CNC VERTICAL MACHINING #1 1- Machine as per Folio FA405 and Dwg D3278 2- Deburr and Tumble Identify as D3278-1 | | |
| 4.0 | QC2 | INSPECT PARTS AS THEY COME OFF MACHINE |
| | | |
| Comment: INSPECT PARTS AS THEY COME OFF MACHINE | | |
| 5.0 | QC8 | SECOND CHECK |
| | | |
| Comment: SECOND CHECK | | |
| 6.0 | HAND FINISHING1 | HAND FINISHING RESOURCE #1 |
| | | |
| Comment: HAND FINISHING RESOURCE #1 Acid etch and Alodine as per QSI 005 4.1 | | |

Date: Monday, 14/11/2005 8:35:37 AM
User: Alba Panzuto

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SUPPORT

Job Number: 24096A

Part Number: D32781

Job Number:



Seq. #:

Machine Or Operation:

Description :

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

10.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

Job Completion



Date: Monday, 14/11/2005 8:35:39 AM
 User: Alba Panzuto

Process Sheet

| | | | | | | | |
|----------------------------------|---------------------------------------|-----------------|------------------|-------------------------|----------------|------------|------|
| Customer | : CU-DAR001 Dart Helicopters Services | | | Drawing Name | : SUPPORT | | |
| Job Number | : 24096B | | | Part Number | : D32782 | | |
| Estimate Number | : 10462 | | | Drawing Number | : D3278 REV. B | | |
| P.O. Number | : | | | Project Number | : | | |
| This Issue | : 14/11/2005 | S.O. No. | : | Drawing Revision | : B | | |
| Prsh Rev. | : NC | | | Material | : | | |
| First Issue | : / / | Type | : SMALL /MED FAB | Due Date | : 30/11/2005 | | |
| Previous Run | : | | | Qty: | 100 | Um: | Each |
| Written By | : | | | | | | |
| Checked & Approved By | : | | | | | | |
| Comment | : Est:A 04.04.19 New issue KJ/JLM | | | | | | |

Additional Product

Job Number:



| Seq. #: | Machine Or Operation: | Description : |
|--|------------------------------|--|
| 1.0 | M6061T6B1000X02000 | 6061-T6 Bar 1.0" x 2.0" |
| 2.0 | SHEAR | SHEAR |
| Comment: SHEAR Cut blank: 2.00" x 1.00" x 2.550" long | | |
| 3.0 | HAAS1 | HAAS CNC VERTICAL MACHINING #1 |
| Comment: HAAS CNC VERTICAL MACHINING #1 1- Machine as per Folio FA405 and Dwg D3278 2- Deburr and Tumble Identify as D3278-2 | | |
| 4.0 | QC2 | INSPECT PARTS AS THEY COME OFF MACHINE |
| Comment: INSPECT PARTS AS THEY COME OFF MACHINE | | |
| 5.0 | QC8 | SECOND CHECK |
| Comment: SECOND CHECK | | |
| 6.0 | HAND FINISHING1 | HAND FINISHING RESOURCE #1 |
| Comment: HAND FINISHING RESOURCE #1 Acid etch and Alodine as per QSI 005 4.1 | | |

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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SUPPORT

Job Number: 24096B

Part Number: D32782

Job Number:



Seq. #: Machine Or Operation:

Description :

7.0 POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

8.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



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9.0 PACKAGING 1

PACKAGING RESOURCE #1



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Identify and Stock

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DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

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